

Work Order ID 65622

January 20, 2011 11:20:37 AM



Page 1

Item ID:	D4017-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Short Basket Base Assembly (350)					
Start Date:	1/21/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/04/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4017	C

100	Weld per dwg A/R S.S. rod Batch: <u>1119649</u>	0.00	11/02/03
	Large Fab		
Large Fab	Memo	0.00	

1- assemble ribs , weld as per dwg D4017 using DT9610B ✓
 inspect before welding mesh
 2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
 and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D4017
 take lid to locate hinge and bracket

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00	11-02-04
	QC		
Quality Control	Memo	0.00	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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January 20, 2011 11:20:37 AM

Page 2

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Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-02-7

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 65622

January 20, 2011 11:20:38 AM



Page 3

Item ID: D4017-041

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Setup Start



Revision ID:

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Item Name: Short Basket Base Assembly (350)

Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

11/15/95L

1ST COAT:

START TIME: 1:10

OVEN TEMPERATURE: 400°

FINISH TIME: 1:40

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 BL 1102-7

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 Q 11/02/11

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Work Order ID 65622

January 20, 2011 11:20:45 AM



Page 4

Item ID: D4017-041

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Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Assemble as per dwg

0.00

= 7



HandFinish

Memo

0.00

Hand Finishing

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

wxp on w/o 65932

Memo

0.00

Packaging

~~D350-60~~ D4032-041

11/02/08

1 d

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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January 20, 2011 11:20:45 AM



Page 5

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/08 *[Signature]*
ME
11-02-08

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 20, 2011 11:20:34 AM

Page 1

Work Order ID: 65622

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4017-1 Rib		Manufactured	No			100	Each	3.0000	1	1		11/01/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				3					
				65385				3					
✓ D4017-3 Rib		Manufactured	No			100	Each	0.0000	1	1		11/01/31	
											B65905 ①		
✓ D4017-5 Hinge Rib		Manufactured	No			100	Each	0.0000	1	1		11/01/31	
											B65914 ①		
✓ D4017-7 Rib		Manufactured	No			100	Each	5.0000	1	1		11/01/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
				58929				2					
				64681				3			①		

W/O:		WORK ORDER CHANGES					
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January 20, 2011 11:20:34 AM

Page 2

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Parent Item Name: Short Basket Base Assembly (350)


Start Date: 1/21/11



Required Date: 2/04/11



Start Qty: 1.00


Required Qty: 1.00


✓ D4017-9 Manufactured No 100 Each 4.0000

 Rib


2 2
 *SY 11/01/31*


✓ D3916-041 Manufactured No 100 Each 0.0000

 Rib Assembly
 ✓ D3916-5 Manufactured No 100 Each 7.0000

 Light Rib

(2)
 B64901 → (2) *SY 11/01/31*
 *SY 11/01/31*

✓ D4034-041 Manufactured No 100 Each 2.0000

 Aft Upper Rib Assembly

(1)
 *SY 11/01/31*

✓ D4034-043 Manufactured No 100 Each 0.0000

 Fwd Upper Rib Assembly

B65789 → (1)
 B64905 → (1) *SY 11/01/31*

January 20, 2011 11:20:34 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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January 20, 2011 11:20:34 AM

Page 3

Work Order ID: 65622

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Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

✓ D2581

Manufactured No

100 Each

33.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

33

64112

20

64425

13



11/01/31

✓ D3913-15

Manufactured No

100 Each

5.0000

1

1



Wide Handle Plate

Location

Loc Qty

Loc Code

WA

5

63627

1

64900

4



11/01/31

✓ D4016-1

Manufactured No

100 Each

1.0000

3

3



Hinge Half, Base

Location

Loc Qty

Loc Code

WA

1

64264

1



11/01/31

✓ D4020-3

Manufactured No

100 Each

0.0000

1

1



Mesh (350 Basket Short, Base)

✓ D4020-11

Manufactured No

100 Each

8.0000

2

2



End Mesh, Basket

Location

Loc Qty

Loc Code

WA

8

59413

1

61306

1

64923

6



11/02/03

11/02/03

January 20, 2011 11:20:34 AM

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Page 3

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Page 4

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Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

✓ D4021-1

Manufactured No

100 Each

15.0000

3

3



Handle Plate



11/02/03

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

10

64136

1

64903

9

D2931

Manufactured No

150 Each

738.0000

2



Bumper



11/2/75

Location

Loc Qty

Loc Code

ST504

738

46064

738

D4021-5

Manufactured No

150 Each

10.0000

2



Blanking Plate



11/2/75

Location

Loc Qty

Loc Code

ST112

10

64243

10

AN3-10A

Purchased No

150 Each

127.0000

6



Bolt



11/2/75

Location

Loc Qty

Loc Code

ST351

127

115877

1

116075

26

116400

100

4X

January 20, 2011 11:20:35 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832 Purchased No

150

Each

10.0000

2

2



Washer



11/16/05 11/2/11

Location

Loc Qty

Loc Code

ST347

10

105059

10

MS20600-AD4W3 Purchased No

150

Each

1,339.000

2

2



Cherry Rivets



11/2/11

Location

Loc Qty

Loc Code

ST321

1339

107939

754

111636

585

MS21042L3 Purchased No

150

Each

3,131.000

6

6



Nut



11/2/11

Location

Loc Qty

Loc Code

ST300

3131

114784

9

115835

622

116391

900

116540

800

116549

800

NASJ149F0332P Purchased No

150

Each

298.0000

12

12



WASHER



11/2/11

Location

Loc Qty

Loc Code

ST275

298

18057

298

12

January 20, 2011 11:20:36 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

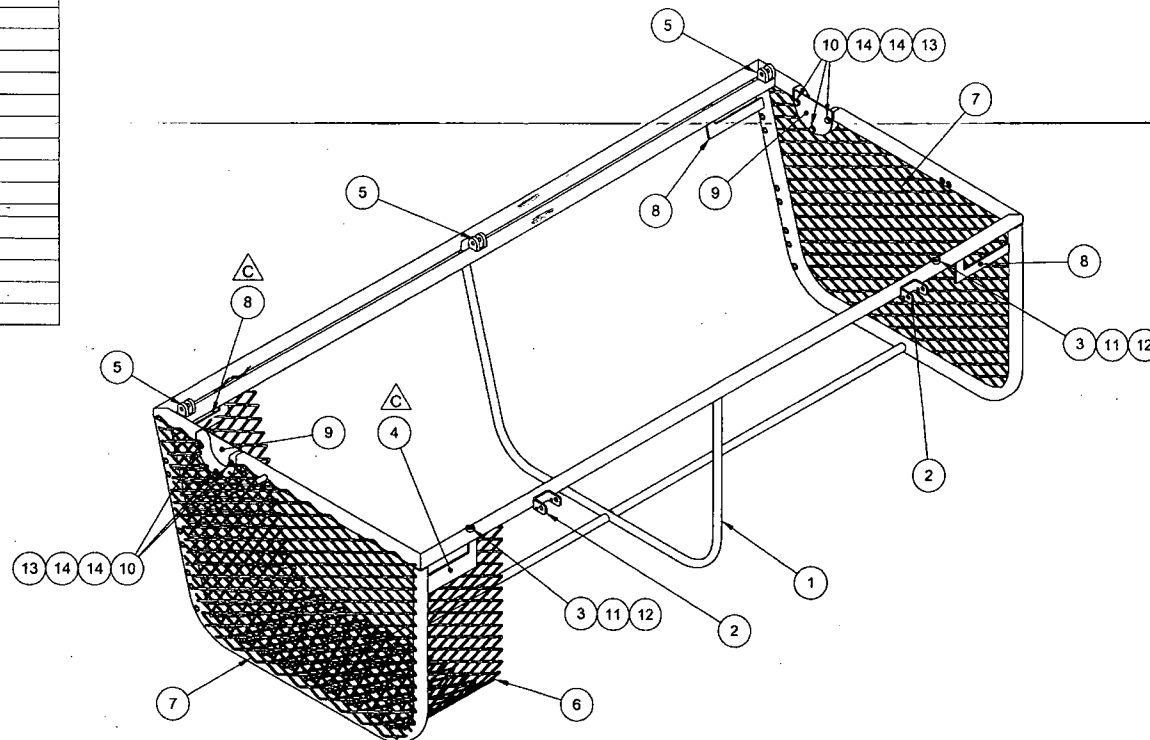
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.08.12

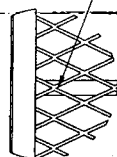
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

W/O 65022

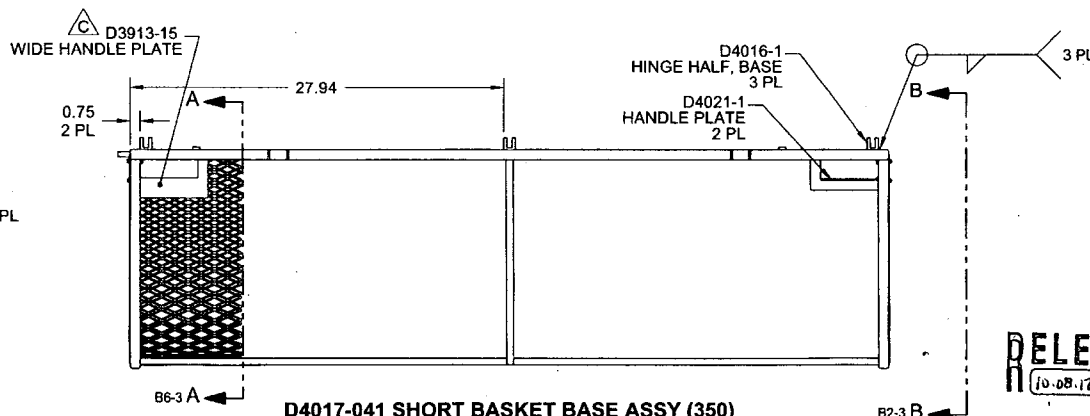
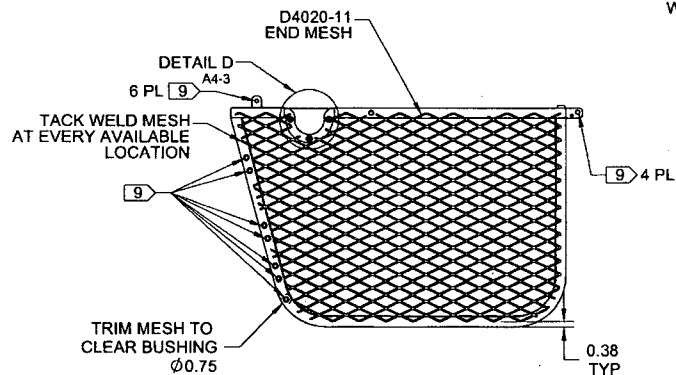
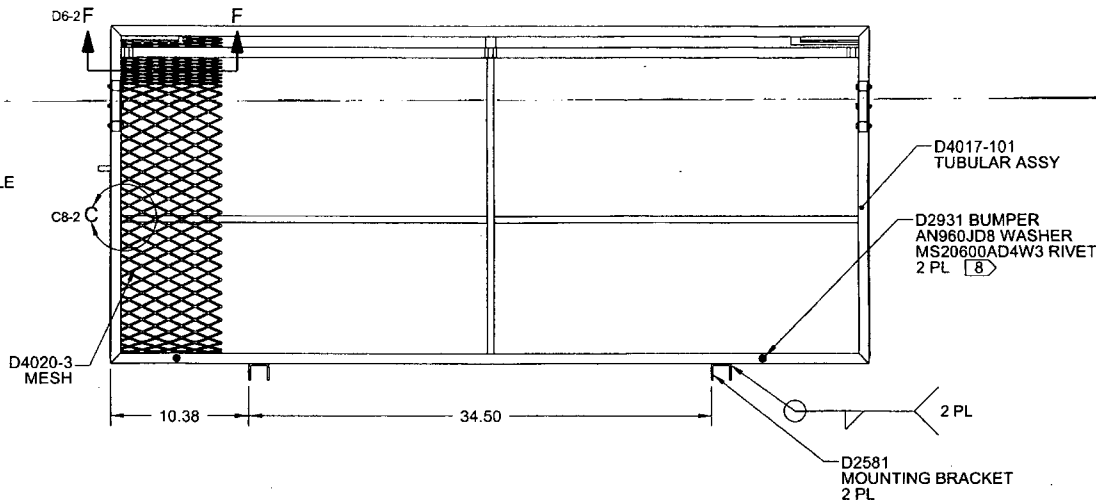
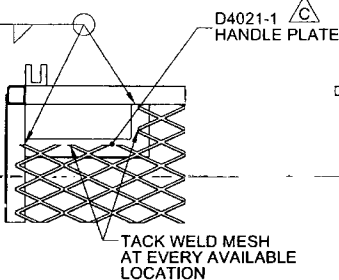
C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	J.F.S.	DRAWING NO.	REV. C
MFG. APPR.	10/1/23	D4017	SHEET 1 OF 5
APPROVED	10/1/23	TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



DETAIL C D5-2

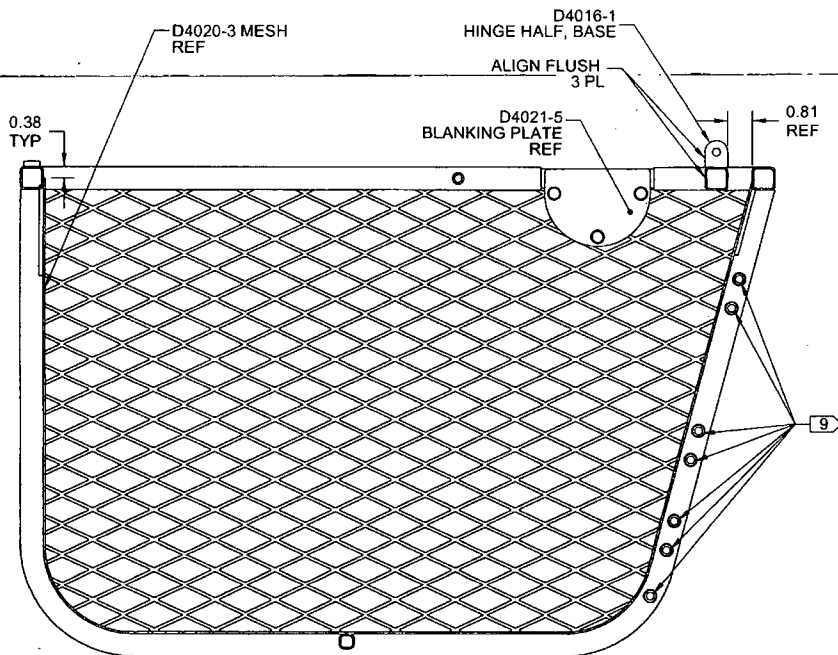
SECTION F-F D5-2
TYPICAL FOR ALL
HANDLE PLATES



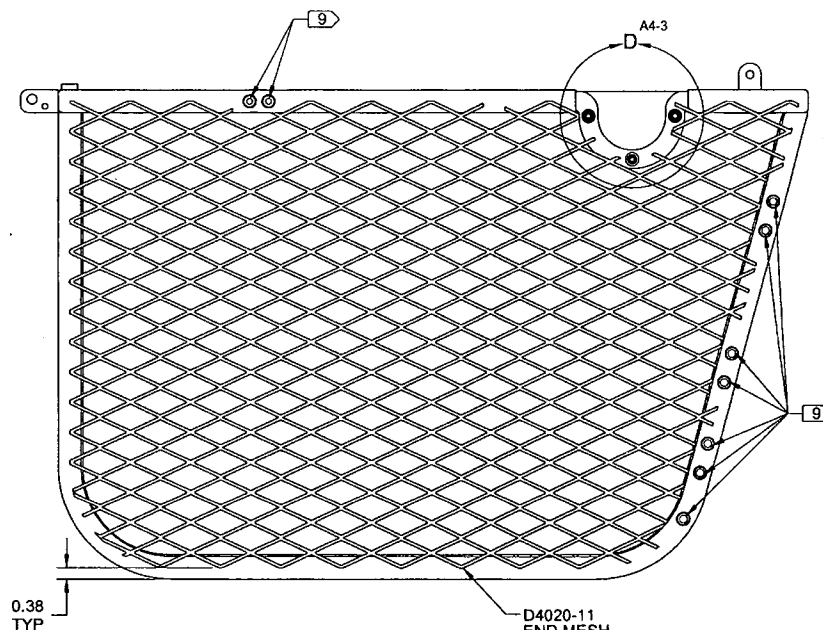
D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12

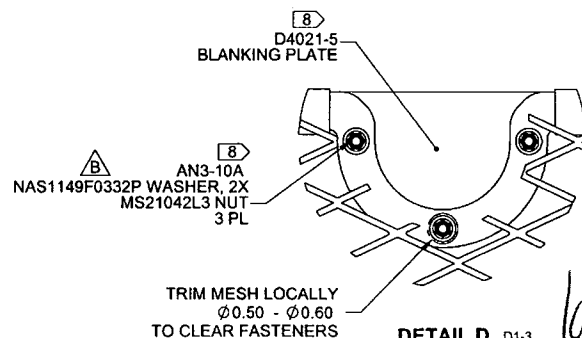
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D4017	REV. C
MFG. APPR.	JES	SHEET 2 OF 5	
APPROVED	JP	SCALE	
DE APPR.	JP	TITLE SHORT BASKET BASE ASSY (350) - NTS.	
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



SECTION A-A A5-2



SECTION B-B A2-2

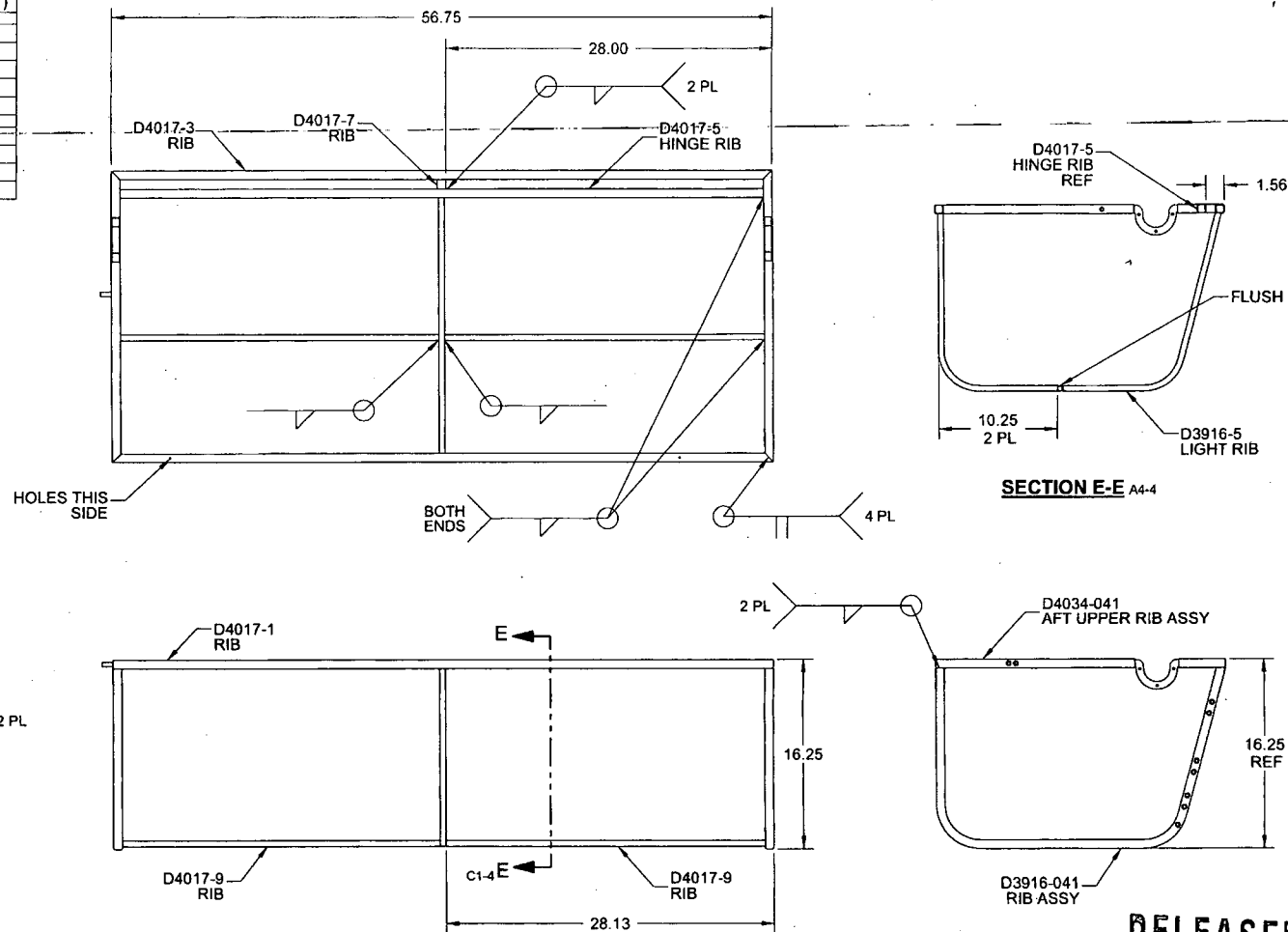


DETAIL D D1-3 B8-2

RELEASED
10.09.12 4

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4017	SHEET 3 OF 5
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	SHORT-BASKET-BASE ASSY (350) -NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	ALS	DART AEROSPACE LTD	REV. C
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.	SYS. B. L.	D4017	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET-BASE ASSY (350) NTS	
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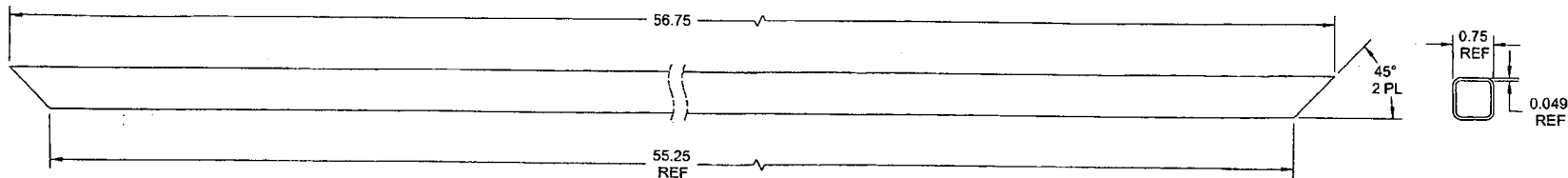
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10.08.17

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8 7 6 5 4 3 2 1

D

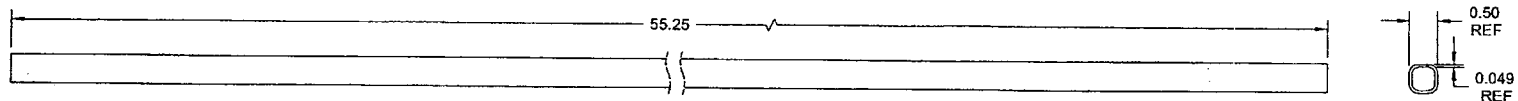
D



D4018-1 RIB

C

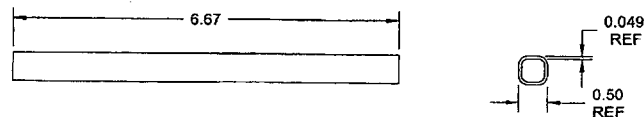
C



D4018-3 RIB

B

B



D4018-5 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

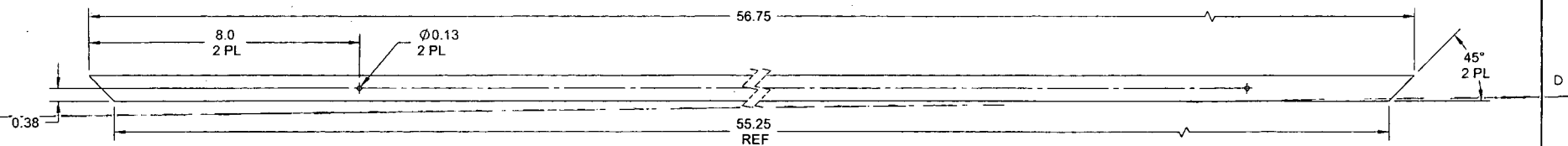
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

65623

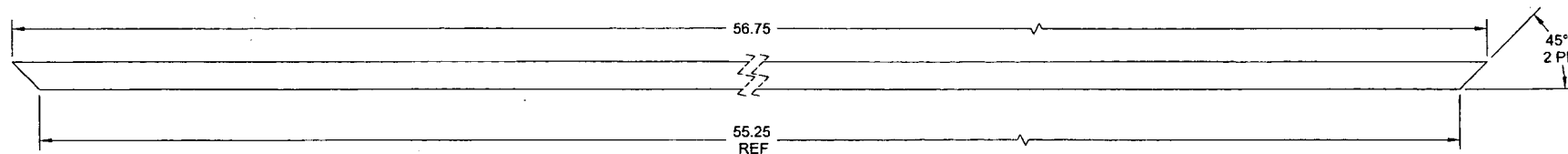
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110.08.12 UP

DESIGN	AIS	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO.	REV. C
MFG. APPR.	ISC	D4018	SHEET 4 OF 4
APPROVED	ISC	TITLE	SCALE
DE APPR.	ISC	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

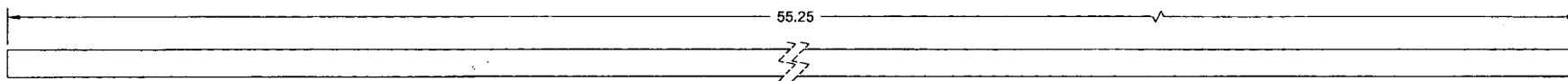
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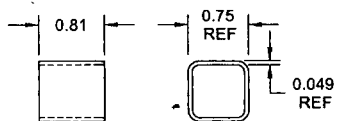
D4017-1 RIB



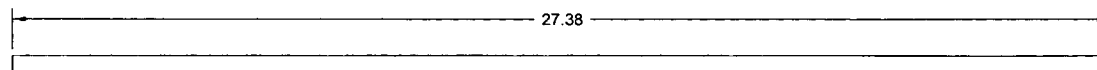
D4017-3 RIB



D4017-5 HINGE RIB



D4017-7 RIB



D4017-9 RIB

NOTES:

1) MATERIAL -1 THRU -7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12.40

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	7/10	DRAWING NO.	REV. C
MFG. APPR.	J.F. G. 12.11.11	D4017	SHEET 5 OF 5
APPROVED	11/11	TITLE	SCALE
DE APPR.	11/11	SHORT BASKET BASE ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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